

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014531**Date Inspected:** 11-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao/ Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW and SAW welding of weld joint 1G-024 located on PCMK SEG3004\* of Segment 12AW welder is identified as 045265 and 066673. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232(1)T-2.

SMAW welding of weld joint 4G-147 located on PCMK SEG3006F of Segment 12CW welder is identified as 037723. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 2F-007 located on PCMK SEG3003F of Segment 12CE welder is identified as 0480381. ZPMC QC is identified as Mr.Zhang guo hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

**OUTSIDE SHOP**

10BW

SMAW welding of weld joint 2G-004 located on PCMK CA073 of Segment 10BW welder is identified as 045204. ZPMC QC is identified as Mr. Tang ya jun. The welding variables recorded by QC appeared to Comply with the

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WPS-345-SMAW-2G(2F)-FCM-Repair-1 and approved

B-CWR1342.

10AW

ABF Quality assurance inspectors doing their UT in bottom plate to side plate of Segment 10AW the weld is identified as SEG059A-007.

10AE

During random in-process visual inspection of OBG segment 10AE, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

An excessive gap was measured at the Intermediate Diaphragm that connects the Deck Plate, I-Stiffener and the Angle Plate (X36E) at panel points 85.5 (Cross Beam side).

-The excessive gap was measured approximately 30mm on the top and 10mm at the bottom.

For more information please see the Incident report

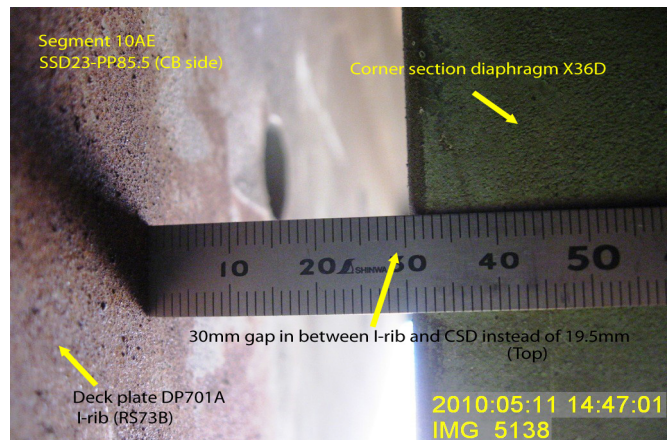
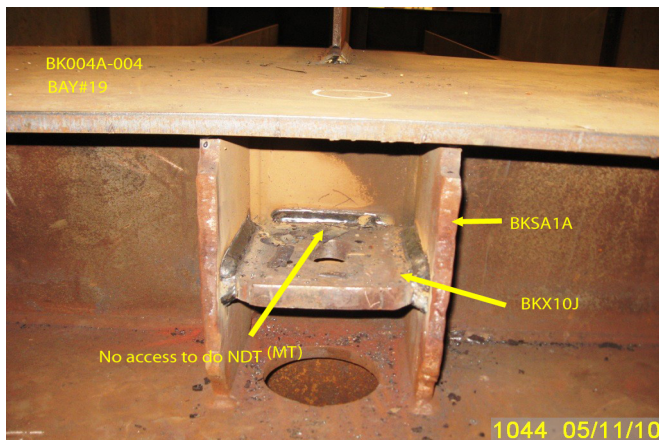
04-0120F4\_TL-15\_B247\_05-11-10\_Excess gap in intermediate bulk head \_at\_10AE

BAY#19

FCAW welding of weld joint 2G-053 located on PCMK BP3017-001 welder is identified as 062786. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

During in process inspection it is found that in re work of Bike path BK004A-004, the sub assembly plate is identified as BKSA1A is connected with BKX10J in between intermediate plate and end plate , there is no access to the NDT(MT) on that weld but ZPMC has submitted RFI for Dye penetration testing instead of Magnetic particle testing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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